

DART
AEROSPACE
S014778

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Fwd Beam

PART NO: D4275-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/28/17

Job No: 167898



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4275-1
Job Sheet 167898



Part No: D4275-1

Job Qty: 5 Ea **(3)**

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Machining		Kt - 17-11-28
100	Bandsaw	5 pcs	12/7/17	12/7/17	0.00	0.52	Bandsaw1		Kt - 17-11-28
110	CNC Vertical Machining	5 pcs	12/7/17	12/7/17	0.71	9.26	HAAS 1		Kt - 17-11-28
120	QC	5 pcs	12/7/17	12/7/17	0.00	0.00	QC2		Kt - 17-11-28
130	QC	5 pcs	12/7/17	12/7/17	0.00	0.00	QC8		17/12/04
140	HandFinish	5 pcs	12/7/17	12/7/17	0.00	0.75	HandFinish1		2017-12-04 JSC
145	Powdercoat	5 pcs	12/8/17	12/8/17	0.00	0.63	Powdercoat1		17/12/05
150	QC	5 pcs	12/8/17	12/8/17	0.00	0.00	QC3		38
180	Packaging	5 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3		9-89
190	QC21-SA	5 Ea	12/8/17	12/8/17	0.00	0.00	QC21		DEC 06 2017

Part Op 100 - Cut Blank to 39.750" Batch: _____

Descriptions: 110 - 1-Machine per folio FB006 2- deburr rough edges

145 - MASK AS PER DWG

M138467 START: 10:10 OUT: 3:30 FINISH: 10:40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X04.000	17	22	0	0

Part Specifications

Specifications could not be found.

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FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.753	✓		31006	H-G
26.700	+/-0.010	26.700	✓		31006	H-G
Ø0.381	+0.000/-0.001	0.381	✓		—	Pin
8.280	+/-0.010	8.280	✓		31006	H-G
1.44	+/-0.030	1.44	✓		Kt-05	vern.
0.95	+/-0.030	0.950	✓		" "	" "
3.50	+/-0.030	3.503	✓		" "	" "
13.28	+/-0.030	13.28	✓		31006	H-G
13.50	+/-0.030	13.50	✓		" "	" "
9.25	+/-0.030	9.25	✓		" "	" "
5.00	+/-0.030	5.00	✓		" "	" "
0.75	+/-0.030	0.750	✓		Kt-05	vern.
2.75	+/-0.030	2.750	✓		" "	" "
3.00	+/-0.030	3.000	✓		" "	" "
1.250	+/-0.010	1.253	✓		31006	H-G
4.50	+/-0.030	4.500	✓		" "	" "
0.734	+/-0.010	0.734	✓		Kt-05	vern.
0.108	+/-0.010	0.107	✓		" "	" "
39.48	+/-0.030	39.490	✓		—	turns
0.95	+/-0.030	0.940	✓		Kt-05	vern.
0.60	+/-0.030	0.595	✓		" "	" "
1.750	+/-0.010	1.748	✓		" "	" "
2.700	+/-0.010	2.700	✓		" "	" "
1.10	+/-0.030	1.100	✓		" "	" "
1.25	+/-0.030	1.250	✓		" "	" "
0.900	+/-0.010	0.900	✓		31006	H-G
0.75	+/-0.030	0.750	✓		Kt-05	vern.
0.250	+/-0.010	0.250	✓		31006	H-G
3.000	+/-0.010	3.000	✓		Kt-05	vern.
1.500	+/-0.010	1.500	✓		" "	" "
Ø0.191	+0.005/-0.001	0.191	✓		Kt-05	vern.

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